

Work Order ID 57502

April 7, 2010 2:39:20 PM



Page 1

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hinge

Start Date: 07/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 14/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *BS*Date: *10-4-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2232

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2232 ☒ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary*BS 10-4-12**(11)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BS 10-4-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Solo 4/12**(11)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57502

April 7, 2010 2:39:20 PM



Page 2

Item ID:	D2232-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Hinge					
Start Date:	07/04/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	14/04/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 	Identify as per dwg & Stock Location: <u>Basket</u>	0.00							
Packaging	Memo	0.00							
Packaging									
150 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

N/A
8

(11) PD 10.04.12

10/04/13

10-4-13

(11)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 7, 2010 2:39:24 PM

Page 1

Work Order ID: 57502

Parent Item: D2232-3

Parent Item Name: Basket Hinge

Comments: IPP B 01.06.07 Now laser cut EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Start Date: 07/04/2010

Required Date: 14/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	33.8200	0.4383	.81		
304/316 0.125 Sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT19

33.82

112663

33.82

112663

11

1810-4-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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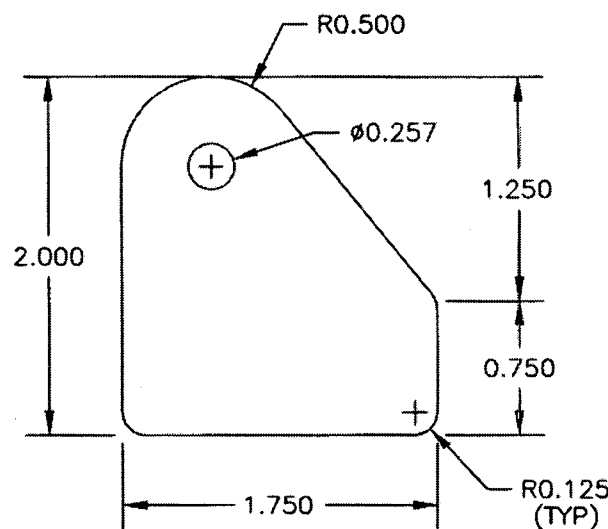
NOTE: Date & initial all entries

DART



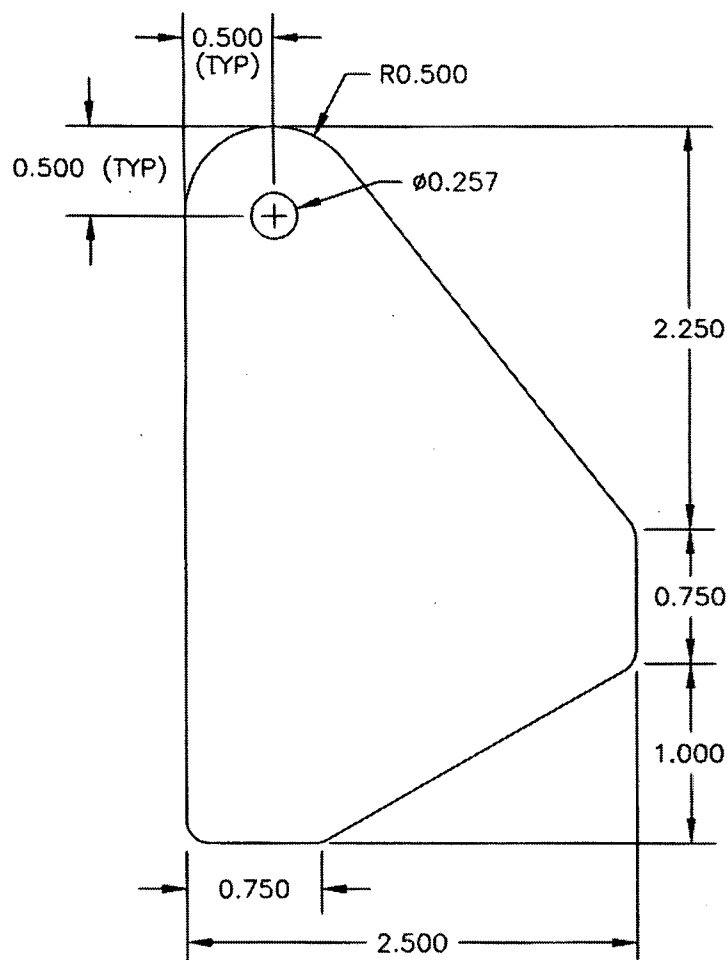
RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	



D2232-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57502
BS10-4-07



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

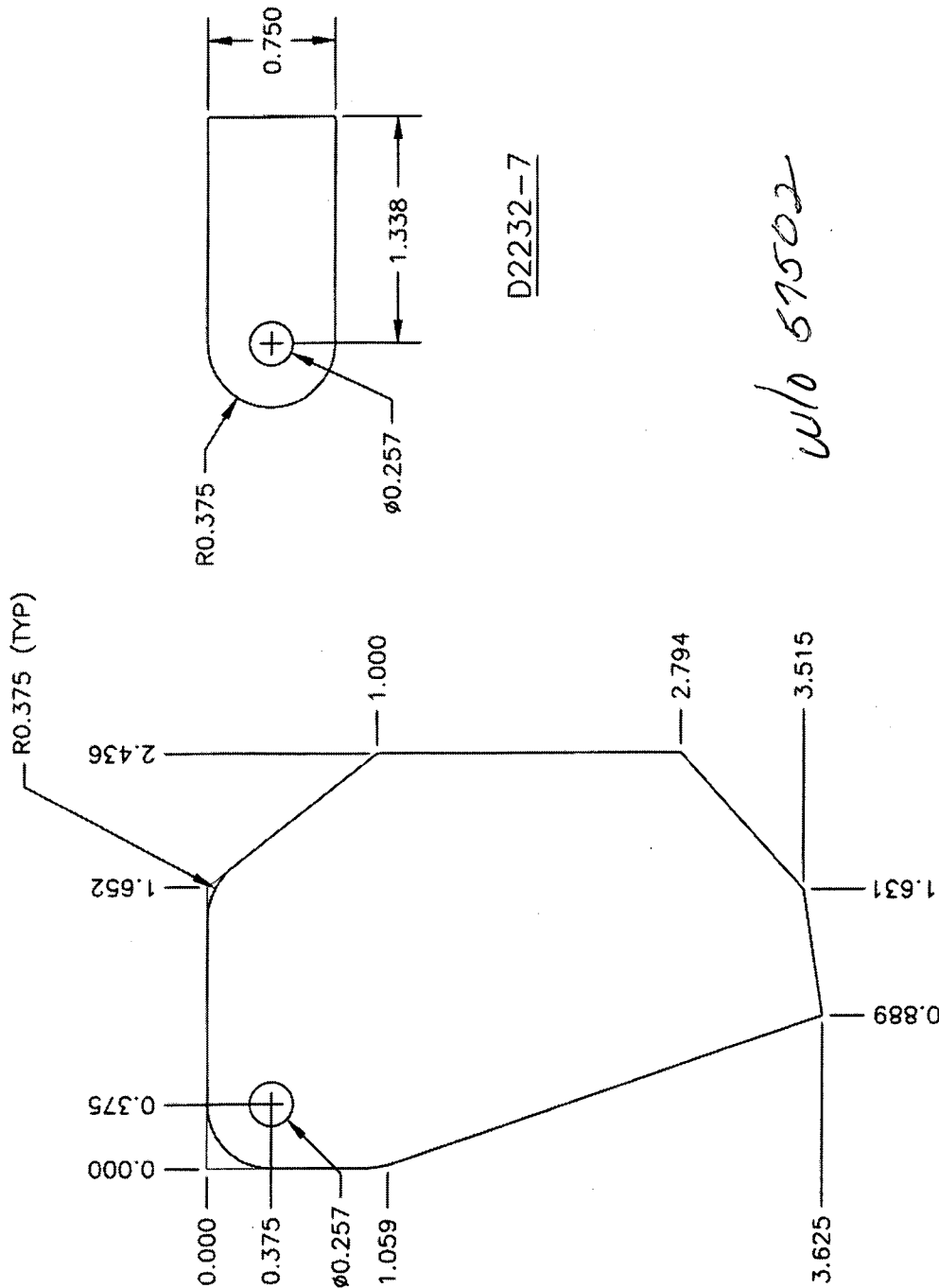
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

w/o 57502

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
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